



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
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D206-642-541
Job Sheet 201420



Part No: D206-642-541

Job Qty: 1 pcs

Part Name: Repl.Skid.,High Gear,Std Wearplates Fits LH/RH, DART Tri-Bag Float Comp.



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 10/3/19

Job Tracking No:

Due Date: 11/8/19

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG D3274-041 REV G IPP Rev:F 08-06-02 add comment DD verified by:EC IPP Rev:G 08-10-09 revise details DD verified by:EC IPP REV:H 13.09.05 CHG004/ ECN13-634 DD VERF:JLM IPP REV:I 14.04.28 AS PER ECN14-520 DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard Setup Hrs	Run Hrs	Workcenter/Supplier	Lead Time	Sign-off
110	Skidtubes - 1	1 pcs	11/8/19		0.00	2.17	Skidtubes - 1		
							Skidtubes - 2		
							Skidtubes - 3		
							Skidtubes - 4		
							Skidtubes - 5		
							Skidtubes - 6		
							Skidtubes - 7		
114	QC 5	1 pcs	11/8/19		0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		
							QC 5 - 40		
							QC 5 - 61		
							QC 5 - 81		
116	QC 10	1 pcs	11/8/19		0.00	0.00	QC 10 - 10		
							QC 10 - 18		
							QC 10 - 24		
							QC 10 - 43		



Container No: S226164



Part: D206-642-541

Job No: 201420

Serial No/Batch: S226164

Revision: G

Inspector:

Exp Date:

Instructions: FAA STC SA00475SE 18/10/17, TC, STC SH98-

Dart Aerospace Ltd.
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CANADA
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120 Handfinish - 1-1 Chemical-B4B	1 pcs	11/8/19	0.00 0.68	QC 10 - 50				
				QC 10 - 58				
				QC 10 - 9				
				Handfinish - 1 - 1 - B4B				
				Handfinish - 1 - 2 - B4B				
				Handfinish - 1 - 3 - B4B				
				Handfinish - 1 - 4 - B4B				
				Handfinish - 1 - 5 - B4B				
				Handfinish - 1 - 6 - B4B				
				Handfinish - 1 - 7 - B4B				
				Handfinish - 1 - 8 - B4B				
				Handfinish - 1 - 9 - B4B				
				Handfinish - 1 - 10 - B4B				
				Handfinish - 1 - 11 - B4B				
				Handfinish - 1 - 12 - B4B				
				Handfinish - 1 - 13 - B4B				
				Handfinish - 1 - 14 - B4B				
				Handfinish - 1 - 15 - B4B				
				Handfinish - 1 - 16 - B4B				
				Handfinish - 1 - 17 - B4B				
				Handfinish - 1 - 18 - B4B				
				Handfinish - 1 - 19 - B4B				
				Handfinish - 1 - 20 - B4B				
				Handfinish - 1 - 21 - B4B				
				Handfinish - 1 - 22 - B4B				
130 QC 7	1 pcs	11/8/19	0.00 0.00	QC 7 - 10				
				QC 7 - 13				
				QC 7 - 14				
				QC 7 - 15				
				QC 7 - 17				
				QC 7 - 18				
				QC 7 - 19				
				QC 7 - 2				
				QC 7 - 28				
				QC 7 - 3				
				QC 7 - 30				
				QC 7 - 34				
				QC 7 - 36				
				QC 7 - 37				
				QC 7 - 41				
				QC 7 - 47				
				QC 7 - 48				
				QC 7 - 51				
				QC 7 - 58				
				QC 7 - 59				
				QC 7 - 60				
				QC 7 - 9				
				QC 7 - 68				
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						QC 7 - 50	
						QC 7 - 67	
						QC 7 - 40	
						QC 7 - 24	
						QC 7 - 43	
						QC 7 - 61	
						QC 7 - 81	
						QC 7 - 76	
						QC 7 - 79	
150 Skidtubes - 2 - B4B	1 pcs	11/8/19	0.00 2.08			Skidtubes - 1 - B4B	
						Skidtubes - 2 - B4B	
						Skidtubes - 3 - B4B	
						Skidtubes - 4 - B4B	TF
						Skidtubes - 5 - B4B	
						Skidtubes - 6 - B4B	
						Skidtubes - 7 - B4B	
160 QC 5	1 pcs	11/8/19	0.00 0.00			QC 5 - 10	
						QC 5 - 12	
						QC 5 - 17	
						QC 5 - 18	BE
						QC 5 - 19	
						QC 5 - 22	
						QC 5 - 24	
						QC 5 - 3	
						QC 5 - 43	
						QC 5 - 49	
						QC 5 - 51	
						QC 5 - 58	
						QC 5 - 68	
						QC 5 - 9	
						QC 5 - 50	
						QC 5 - 30	
						QC 5 - 40	
						QC 5 - 61	
						QC 5 - 81	
170 Skidtubes - 3 - B4B	1 pcs	11/8/19	0.00 2.17			Skidtubes - 1 - B4B	
						Skidtubes - 2 - B4B	
						Skidtubes - 3 - B4B	mba
						Skidtubes - 4 - B4B	
						Skidtubes - 5 - B4B	
						Skidtubes - 6 - B4B	
						Skidtubes - 7 - B4B	
180 QC 5	1 pcs	11/8/19	0.00 0.00			QC 5 - 10	
						QC 5 - 12	
						QC 5 - 17	
						QC 5 - 18	BE
						QC 5 - 19	
						QC 5 - 22	
						QC 5 - 24	
						QC 5 - 3	
						QC 5 - 43	
						QC 5 - 49	
						QC 5 - 51	
						QC 5 - 58	
						QC 5 - 68	
						QC 5 - 9	
						QC 5 - 50	
						QC 5 - 30	
						QC 5 - 40	

				QC 5 - 61	
				QC 5 - 81	
190 Skidtubes - 4 - B4B	1 pcs	11/8/19	0.00 2.75	Skidtubes - 1 - B4B	
				Skidtubes - 2 - B4B	
				Skidtubes - 3 - B4B	
				Skidtubes - 4 - B4B	TF
				Skidtubes - 5 - B4B	BZ
				Skidtubes - 6 - B4B	
				Skidtubes - 7 - B4B	
200 QC 5	1 pcs	11/8/19	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	DAS NOV 25 2019 68
				QC 5 - 9	9-89
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
				QC 5 - 61	
				QC 5 - 81	
				210 QC 10	1 pcs
QC 10 - 18					
QC 10 - 24					
QC 10 - 43					
QC 10 - 50					
QC 10 - 58					
QC 10 - 9					
220 Handfinish - 2-1 Pressure- B4B	1 pcs	11/8/19	0.00 0.45	Handfinish - 2 - 1 - B4B	
				Handfinish - 2 - 2 - B4B	NOV 25 2019
				Handfinish - 2 - 3 - B4B	
				Handfinish - 2 - 4 - B4B	
230 Spray Paint - 2 - B4B	1 pcs	11/8/19	0.00 0.40	Spray Paint - 1 - B4B	
				Spray Paint - 2 - B4B	• R019.12.4
				Spray Paint - 3 - B4B	
				Spray Paint - 4 - B4B	
240 QC 14	1 pcs	11/8/19	0.00 0.00	QC 14 - 15	
				QC 14 - 2	
				QC 14 - 34	
				QC 14 - 41	
				QC 14 - 51	
				QC 14 - 58	
				QC 14 - 59	BEB19-12-05
				QC 14 - 9	
				QC 14 - 68	
				QC 14 - 40	
				QC 14 - 19	
				QC 14 - 43	
				QC 14 - 24	
				QC 14 - 61	
				QC 14 - 81	
				244 Handfinish - 3-1- WingWalk-	1
				Plex 10/3/19 10:40 AM Dart.lajeunesse.marie	

B4B	pcs				Handfinish - 3 - 2 - B4B	BEB19-12-05
					Handfinish - 3 - 3 - B4B	
					Handfinish - 3 - 4 - B4B	
					Handfinish - 3 - 5 - B4B	
246 QC 3	1 pcs	11/8/19	0.00	0.00	QC 3 - 10	ML 14-12-5
					QC 3 - 13	
					QC 3 - 15	
					QC 3 - 17	
					QC 3 - 18	
					QC 3 - 2	
					QC 3 - 28	
					QC 3 - 3	
					QC 3 - 30	
					QC 3 - 34	
					QC 3 - 36	
					QC 3 - 41	
					QC 3 - 51	
					QC 3 - 58	
					QC 3 - 59	
					QC 3 - 68	
					QC 3 - 9	
					QC 3 - 40	
					QC 3 - 19	
					QC 3 - 43	
					QC 3 - 24	
					QC 3 - 61	
					QC 3 - 81	
250 Handfinish - 4-1-Assembly-B4B	1 pcs	11/8/19	0.00	0.45	Handfinish - 4 - 1 - B4B	BEB19-12-05
					Handfinish - 4 - 10 - B4B	
					Handfinish - 4 - 11 - B4B	
					Handfinish - 4 - 12 - B4B	
					Handfinish - 4 - 13 - B4B	
					Handfinish - 4 - 14 - B4B	
					Handfinish - 4 - 15 - B4B	
					Handfinish - 4 - 2 - B4B	
					Handfinish - 4 - 3 - B4B	
					Handfinish - 4 - 4 - B4B	
					Handfinish - 4 - 5 - B4B	
					Handfinish - 4 - 6 - B4B	
					Handfinish - 4 - 7 - B4B	
					Handfinish - 4 - 8 - B4B	
					Handfinish - 4 - 9 - B4B	
260 QC 5	1 pcs	11/8/19	0.00	0.00	QC 5 - 10	
					QC 5 - 12	
					QC 5 - 17	
					QC 5 - 18	
					QC 5 - 19	
					QC 5 - 22	
					QC 5 - 24	
					QC 5 - 3	
					QC 5 - 43	
					QC 5 - 49	
					QC 5 - 51	
					QC 5 - 58	

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					QC 5 - 68	
					QC 5 - 9	
					QC 5 - 50	
					QC 5 - 30	
					QC 5 - 40	
					QC 5 - 61	
					QC 5 - 81	
270 Handfinish - 4-2-Assembly-B4B	1 pcs	11/8/19	0.00 0.68	Handfinish - 4 - 1 - B4B		rel 14-12-05
				Handfinish - 4 - 10 - B4B		
				Handfinish - 4 - 11 - B4B		
				Handfinish - 4 - 12 - B4B		
				Handfinish - 4 - 13 - B4B		
				Handfinish - 4 - 14 - B4B		
				Handfinish - 4 - 15 - B4B		
				Handfinish - 4 - 2 - B4B		
				Handfinish - 4 - 3 - B4B		
				Handfinish - 4 - 4 - B4B		
				Handfinish - 4 - 5 - B4B		
				Handfinish - 4 - 6 - B4B		
				Handfinish - 4 - 7 - B4B		
				Handfinish - 4 - 8 - B4B		
				Handfinish - 4 - 9 - B4B		
280 QC 5	1 pcs	11/8/19	0.00 0.00	QC 5 - 10		
				QC 5 - 12		
				QC 5 - 17		
				QC 5 - 18		
				QC 5 - 19		
				QC 5 - 22		
				QC 5 - 24		
				QC 5 - 3		
				QC 5 - 43		
				QC 5 - 49		
				QC 5 - 51		
				QC 5 - 58		
				QC 5 - 68		DAS DEC 06 2019 68 9-89
				QC 5 - 9		
				QC 5 - 50		
				QC 5 - 30		
				QC 5 - 40		
				QC 5 - 61		
				QC 5 - 81		
290 Packaging 3-1 - Stock - B4B	1 pcs	11/8/19	0.00 0.00	Packaging 3 - 1 - B4B		
				Packaging 3 - 2 - B4B		
				Packaging 3 - 3 - B4B		
				Packaging 3 - 4 - B4B		
				Packaging 3 - 5 - B4B		
				Packaging 3 - 6 - B4B		
				Packaging 3 - 7 - B4B		
				Packaging 3 - 8 - B4B		
				Packaging 3 - 9 - B4B		
				Packaging 3 - 10 - B4B		
				Packaging 3 - 11 - B4B		
				Packaging 3 - 12 - B4B		
				Packaging 3 - 13 - B4B		

				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	DAS
				Packaging 3 - 25 - B4B	78 DEC 1 0 2019
				Packaging 3 - 26 - B4B	9-89
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	DAS
295 DC - 1 - B4B	1	11/8/19	0.00 0.00	DC - 1 - B4B	21 DEC 1 0 2019
	pcs			DC - 2 - B4B	9-89
300 QC 21 - FG	1	11/8/19	0.00 0.00	QC 21 - FG - 21	DAS
	pcs			QC 21 - FG - 70	21 DEC 1 0 2019
				QC 21 - FG - 53	9-89

Part Op 110 - (Skidtubes) ****VERIFY AND INSPECT THE MATERIAL PRIOR TO USE**** 1- remove fwd indexing ridge as per Descriptions: dwg D3274. Prepare for welding 2- weld fwd cap as per dwg D3274 and QSI004 AR Aluminum Rod Batch: 138989/139011 3- grind fwd cap weld on top surface only 4- Cut AFT end of tube at 170.9" as per dwg D3274 and deburr end. 5-Drill Aft cap pilot hole using DT8025 6 -Cleco DT8025 in position and install pilot hole drill Jig DT8742A,B,C,D and DT8742. Drill 3/16" pilot holes as per Dwg D3274 7 -Remove inner indexing ridge on aft end of skidtube as per Dwg D3274 scribe batch # 8 -Open aft end cap holes to Ø0.208" as per Dwg D3274. Deburr aft end.

114 - (QC5- Inspect part completeness to step on W/O)
 116 - (QC10- Inspect visual per QSI004- ground welds)
 120 - (Chemical Conversion Coat per QSI005 4.1)
 130 - (QC7-Inspect Chemical Conversion Coat)
 150 - (Skidtubes) 1-Open Ø0.313" and 0.375" crossbolt spacer holes as per Dwg D3274 2-Deburr crossbolt spacer holes as per Dwg D3274 and blow out chips from inside the tube 3-Bond web in place as per Dwg D3274 & QSI 015. (Adhere for 12 hours)
 160 - (QC5- Inspect part completeness to step on W/O)
 170 - (Skidtubes) 1-Bend AFT end of tube using bend prog. D3274 AFT as per dwg D3274. Install drop pins in crossbolt spacer holes to maintain web position. 2- DRILL PILOT HOLES FOR WEARPLATES USING D3274-1T2 OPEN HOLES TO .297" . Deburr 3-DRILL TOE PIN HOLE .640" DIA AS PER DWG USING DT8935 FWD END OF TUBE DEBURR INSIDE OF HOLE AS NECESSARY (DO NOT ENLARGE HOLES) REMOVE ANY FOREIGN OBJECTS INSIDE OF TUBES 4- Countersink crossbolt spacer holes as per Dwg D3274 5- prepare for welding
 180 - (QC5- Inspect part completeness to step on W/O)
 190 - (Skidtubes) 1-Insert D2649 & D3275-1 crossbolt spacers. Weld as per QSI 004 and Dwg D3274. Remember to back drill each hole before welding the other side. Use aluminum rod 3-Grind cross bolt welds flush as per Dwg D3274. ****INSPECT FOR PIN HOLES IN WELD**** 4-Counterbore 5/16" x 0.750" deep as per Dwg D3274 and deburr.
 200 - (QC5- Inspect part completeness to step on W/O)
 210 - (QC10- Inspect visual per QSI004- ground welds)
 220 - (Pressure Wash per QSI005 4.3/ Clean and remove all markings) Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch
 230 - (Spray Paint / NDT Room) Make sure Nut Plate Thread is protected using paint screw., 1- PRIME AS PER DWG AND QSI 005 4.2 PRIMER PRC DESOTO 515X349 BATCH: 5218188 2- PAINT WHITE AS PER DWG AND QSI 005 4.2 PAINT BATCH: 4231052
 240 - (QC14- Inspect Spray Paint)
 244 - (Wing Walk as per dwg QSI005 4.4 Batch 5229693.
 246 - (QC3- Inspect Part Finish)
 250 - (Assemble as per dwg) 1-Install Nut Plate as per Dwg D3274. Apply LPS-PROCYON to Nut Plate and rivets.
 260 - (QC5- Inspect part completeness to step on W/O) Inspect Nut Plate & Inserts
 270 - (Assemble as per dwg) 1-Install wearpads as per Dwg D3274. 2-Install ring as per Dwg D3274 3-Inspect for foreign objects as per QSI 024 4-Install Aft Cap and seal with Sikaflex. Clean excess adhesive.
 280 - (QC5- Inspect part completeness to step on W/O)

Sikaflex
 5200625
 exp 07.25.20

A/R
 138989

290 - (Identify as per dwg & Stock Location: _____) Location : FG073

295 - (Document Control) Photocopy bluefile & type labels per PPP D206-642- 541 CHG005

300 - (QC21- Final Inspection - Work Order Release) 4-Counterbore 5/16" x 0.750" deep as per Dwg D3274 using DT10280 and deburr.

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D3274-041BENT	Skidtube Assembly 206	1 pcs (1 ea)	110-Skidtubes - 1	5216847
D3285-1	Cap	1 pcs (1 ea)	110-Skidtubes - 1	5043738
D3282-041	Float Web (206L/407)	1 pcs (1 ea)	150-Skidtubes - 2 - B4B	5215825
D2649	Cross Bolt Spacer	12 pcs (12 ea)	190-Skidtubes - 4 - B4B	5227234
D3275-1	Cross Bolt Spacer	12 pcs (12 ea)	190-Skidtubes - 4 - B4B	3199330
ALS4-1032-130	Rivnut	78 Ea (78 ea)	250-Handfinish - 4-1-Assembly-B4B	44,505 7257/38x 5057258-1
CCR264SS3-3	Cherry Rivet	2 Ea (2 ea)	250-Handfinish - 4-1-Assembly-B4B	5226154
CR3212-4-03	Cherry Rivet	2 Ea (2 ea)	250-Handfinish - 4-1-Assembly-B4B	5163230-3
D3415-041	Nut Plate	1 pcs (1 ea)	250-Handfinish - 4-1-Assembly-B4B	5218586
AN3C4A	Bolt	80 Ea (80 ea)	270-Handfinish - 4-2-Assembly-B4B	5220803-1
AN4C5A	Bolt	1 Ea (1 ea)	270-Handfinish - 4-2-Assembly-B4B	5225261
D2646	Aft Cap	1 pcs (1 ea)	270-Handfinish - 4-2-Assembly-B4B	5197616
D3413-1	O-Ring	1 pcs (1 ea)	270-Handfinish - 4-2-Assembly-B4B	165886
D3537-1	Wearpad	9 pcs (9 ea)	270-Handfinish - 4-2-Assembly-B4B	5229957
D3537-3	Wearpad	1 pcs (1 ea)	270-Handfinish - 4-2-Assembly-B4B	5218982
D3672-1	Washer, Phenolic	2 pcs (2 ea)	270-Handfinish - 4-2-Assembly-B4B	F164008
D4956-15	Wearplate Fwd	1 pcs (1 ea)	270-Handfinish - 4-2-Assembly-B4B	5218063
D4956-23	Wearplate Center Fwd	1 pcs (1 ea)	270-Handfinish - 4-2-Assembly-B4B	5232473
D4956-35	Wearplate Aft	1 pcs (1 ea)	270-Handfinish - 4-2-Assembly-B4B	520621209 983
D4956-39	Wearplate Center Aft	1 pcs (1 ea)	270-Handfinish - 4-2-Assembly-B4B	5201005
NAS1149C0332R	Washer (AN960C10L)	80 Ea (80 ea)	270-Handfinish - 4-2-Assembly-B4B	5233308
NAS1149C0463R	Washer (AN960C416)	1 Ea (1 ea)	270-Handfinish - 4-2-Assembly-B4B	5104373

M.U. 013285

M.U. 013291

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
110-Skidtubes - 1	D3274-041BENT	1	9	0
	D3285-1	1	1	0
150-Skidtubes - 2 - B4B	D3282-041	1	2	0
190-Skidtubes - 4 - B4B	D2649	12	51	0
	D3275-1	12	145	0
250-Handfinish - 4-1-Assembly-B4B	ALS4-1032-130	78	5,828	0
	CCR264SS3-3	2	45	0
	CR3212-4-03	2	132	0
	D3415-041	1	48	0
270-Handfinish - 4-2-Assembly-B4B	AN3C4A	80	682	0
	AN4C5A	1	59	0
	D2646	1	47	0
	D3413-1	1	16	0
	D3537-1	9	110	0
	D3537-3	1	29	0
	D3672-1	2	1,411	0
	D4956-15	1	22	0
	D4956-23	1	15	0
	D4956-35	1	20	0
	D4956-39	1	19	0
	NAS1149C0332R	80	4,125	0
	NAS1149C0463R	1	196	0

Part Specifications

Specifications could not be found.

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Qty	Qty	Part Number	Description
1	X	D3274-041	SKIDTUBE ASSEMBLY
1	X	D3274-043	SKIDTUBE ASSEMBLY
1	X	D3274-046	SKIDTUBE ASSEMBLY (FOR PH)
1	1	D2600-1-240	EXTRUSION
1	1	D2646	AFT CAP
12	12	D2648	CROSS BOLT SPACER
12	37	D3275-1	CROSS BOLT SPACER
1	1	D3282-041	FLOAT WEB
1	1	D3285-1	CAP
1	1	D413-1	RING
1	1	D415-041	MULTI PLATE
9	9	D357-1	WEARPAD
1	1	D357-9	WEARPAD
1	1	D357-11	WEARPAD
2	2	D3672-1	WASHER
1	1	D455-15	WEARSHOE
1	1	D455-23	WEARSHOE
1	1	D455-35	WEARSHOE
1	1	D455-38	WEARSHOE
78	40	AL57-1032-130	INSERT (FOR AK94-1032-130, AL54-1032-130, AEL5-1032-130)
80	42	AN3CA	BOLT
1	1	AN4CA	BOLT
1	1	NAS1149C0463R	WASHER (AN880C16)
80	42	NAS1149C0332R	WASHER (AN880C10L)
2	2	CR3212-4-09	RIVET
1	1	MS27039C4-06	SCREW

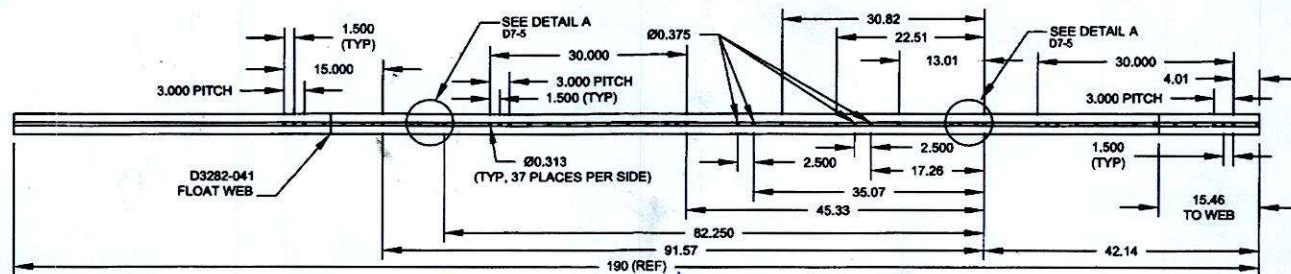
1. MATERIAL: N/A
2. FINISH:
3. CHEMICAL CONVERSION COAT PER PART QSI 005 4.1 PRIOR TO INSTALLING D3282-041 WEB
- PRIME (REF: 4.2, 1.3.3) OUTSIDE ONLY AND PAINT WHITE PER PART QSI 006 4.2
- BLACK ANTI-SKID PAINT AS INDICATED TO 0.5" ABOVE LOCATION RIDGE PER PART QSI 005 4.4
4. UNITS: INCHES UNLESS OTHERWISE NOTED
5. BREAK SHARP EDGES 0.005 TO 0.010 MAX
6. IDENTIFICATION: N/A
7. WEIGHT: FOR -041-043 = 37.5 LBS
8. WELDING TO BE DONE PER PART QSI 004
9. ALL HOLES DRILLED ON CENTERLINES
10. DAMAGE TO SURFACE ON CENTERLINES
11. ABOVE THE GROUND, IT IS ACCEPTABLE TO POLISH OUT GOUGES UP TO 0.020" DEEP IN THE BENT PORTION OF THE TUBE. A MAXIMUM REDUCTION IN DIAMETER OF 0.150" IS ACCEPTABLE IN THE BENT PORTION OF THE TUBE.
12. DRILL Ø0.237 HOLES FOR AL57-1032-130 INSERTS USING D3274-173 BEFORE FINISH. INSTALL AL57-1032-130 INSERTS AFTER FINISH. SEAL WEARSHOE BOLTS WITH SIKAFLEX-241V-251. ON -045, DO NOT DRILL HOLES OR INSTALL INSERTS FOR LONG WEARPLATES.
13. COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES LPS PROCOYON AFTER FINAL ASSEMBLY. CLEAN EXCESS GREASE WITH WASH N WIPE DEGREASER.
14. ON -045, APPLY COAT OF ROCKGUARD TO SKIDTUBE WHERE WEARPADS ARE INSTALLED.

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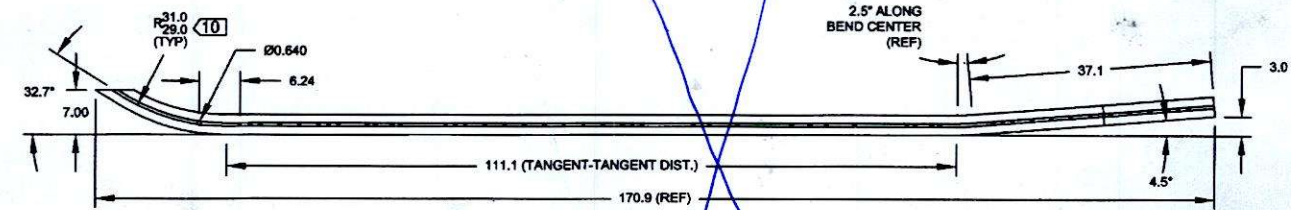
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APPROVED	DS
MFG. APPR.	JLM
CHECKED	AK
DRAWN	RF
DESIGN	CP
DART AEROSPACE USA, INC	
EUGENE, OR	
DRAWING NO.	D3274
REV. G	SHEET 1 OF 6
SCALE	NTS
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REV.	DESCRIPTION	BY	DATE
A	NEW ISSUE	CP	04.03.15
B	MOVE SADDLE HOLE: 42.14 WAS 42.78	CP	04.08.09
C	ADD -043: NEW INSERTS	CP	05.03.16
D	NEW INSERTS, SS WEARSHOE + GASKET	CP	06.12.19
E	WAS POWDERCOAT, REF: PAR13-256	DW	13.05.17
F	REVIS NOTE 2: FINISH NOW PRIME/PAINT	DB	14.04.15
G	REVIS NOTE 2: ADD ANTI-SKID PAINT, REMOVE GASKETS PER IN-D206-042 REV 0	DS	16.04.25

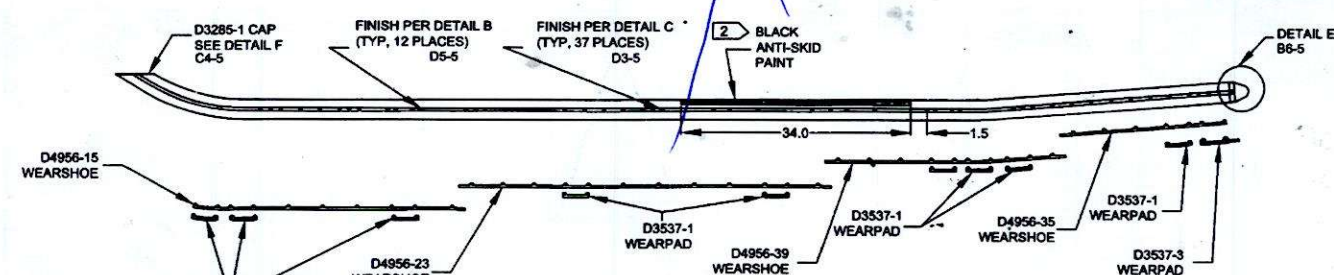
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WORK ORDER
NO. 201420 M15
15-10-03



D3274-043 DRILLING/ASSEMBLY DETAIL



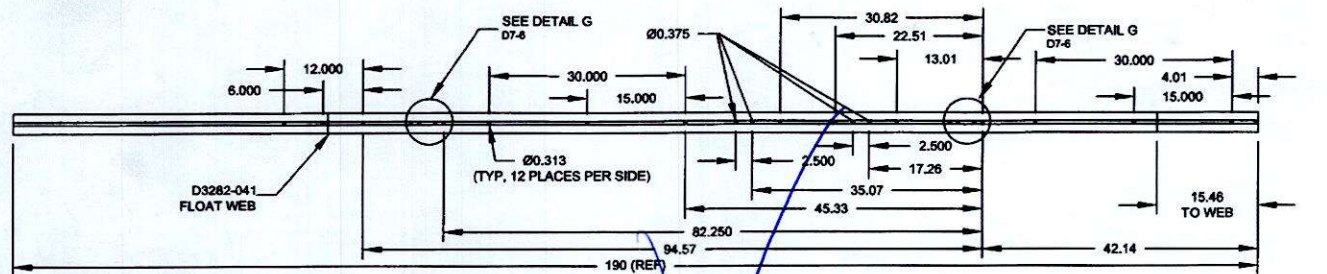
D3274-043 BEND/DRILLING DETAIL



**D3274-043 SKIDTUBE ASSEMBLY
(SEE DETAIL D FOR WEARSHOE INSTALLATION)**

RELEASE
2016-07-26

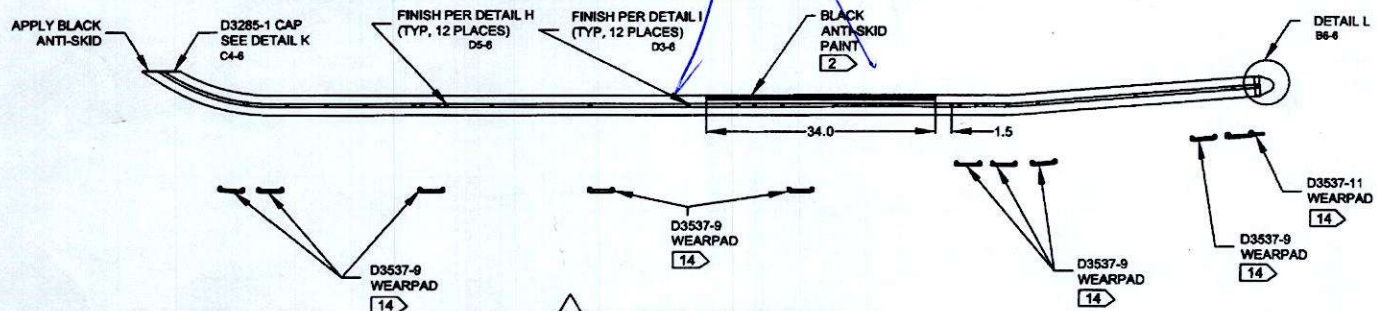
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D3274-045 DRILLING/ASSEMBLY DETAIL



D3274-045 BEND/DRILLING DETAIL

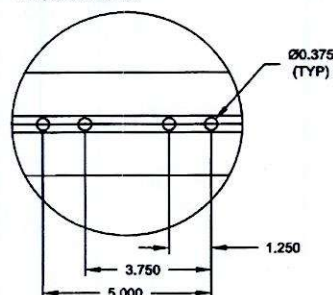


D3274-045 SKIDTUBE ASSEMBLY
(SEE DETAIL J FOR WEARSHOE INSTALLATION)

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2016-07-26

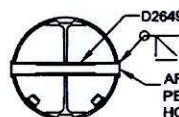
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MFG. APPR.	JLM	D3274	SHEET 4 OF 6
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DETAIL A: DRILL DETAIL
D6-2, D3-2, D5-3, D3-3



DETAIL B
B6-2, B5-3

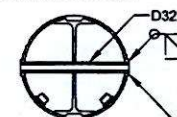
FOR Ø0.375 HOLES ONLY



- AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR Ø0.375
HOLES ONLY:
1. CHAMFER HOLE 0.030x45°
 2. INSERT D2649 SPACER
 3. WELD INTO PLACE AND GRIND FLUSH
 4. C'BORE TO Ø0.313x0.75 DEEP

DETAIL C
B5-2, B4-3

FOR Ø0.313 HOLES ONLY



CHAMFER 0.030x45°
(TYP)

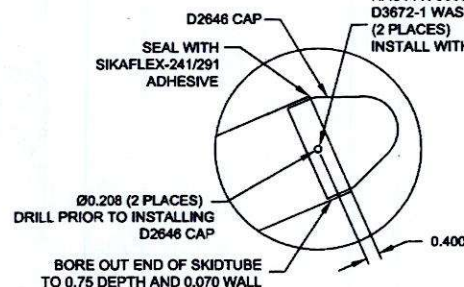
DETAIL D
A4-2, A4-3



- AL57-1032-130 INSERT (1)
AN3C4A BOLT (1)
NAS1149C0332R WASHER (1)
(78 PLACES)

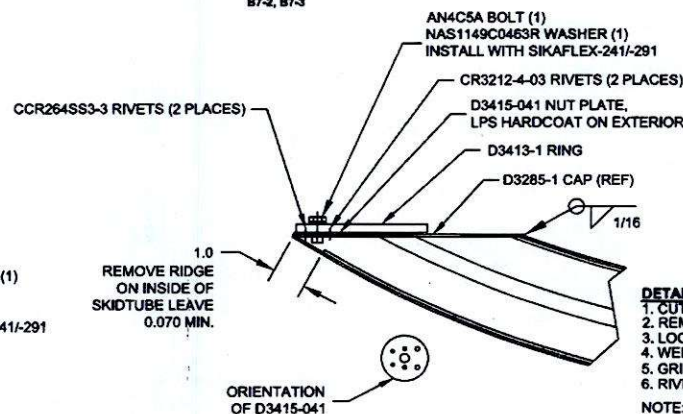
WEARSHOE/WEARPAD (REF)

DETAIL E
B2-2, B2-3



- AN3C4A BOLT (1)
NAS1149C0332R WASHER (1)
D3672-1 WASHER (1)
(2 PLACES)
INSTALL WITH SIKAFLEX-241/291

DETAIL F: END FINISHING DETAIL
B7-2, B7-3



DETAIL F NOTES

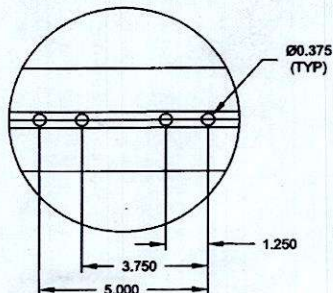
1. CUT TUBE LEVEL
 2. REMOVE RIDGE ON FWD SIDE
 3. LOCATE D3285-1 (TRIM AS NECESSARY)
 4. WELD D3285-1 IN PLACE PER DART QSI 004
 5. GRIND FLUSH
 6. RIVET D3415-041 NUT PLATE IN PLACE
- NOTE: MASK THREADS IN D3415-041
PRIOR TO FINISH

-041/-043 DETAILS

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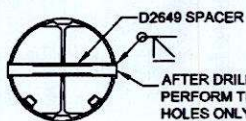
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DETAIL G: DRILL DETAIL
D6-4, D3-4



DETAIL H
B6-4

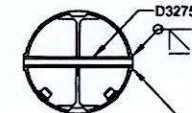
FOR Ø0.375 HOLES ONLY



AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR Ø0.375
HOLES ONLY:
1. CHAMFER HOLE 0.030x45°
2. INSERT D2649 SPACER
3. WELD INTO PLACE AND GRIND FLUSH
4. C'BORE TO Ø0.313x0.75 DEEP

DETAIL I
B5-4

FOR Ø0.313 HOLES ONLY



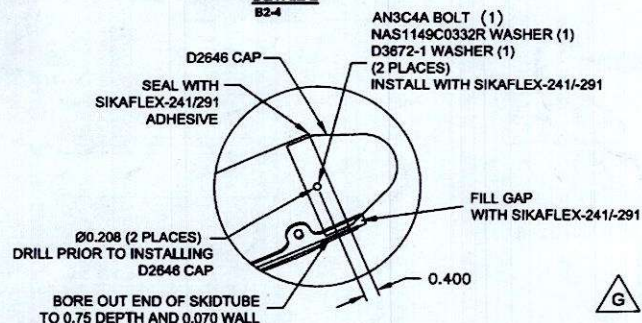
CHAMFER 0.030x45°
(TYP)

DETAIL J
A4-4

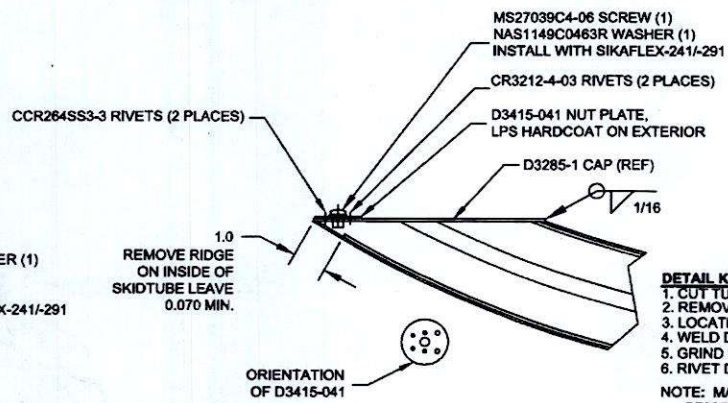


ALS7-1032-130 INSERT (1)
AN3C4A BOLT (1)
NAS1149C0332R WASHER (1)
(40 PLACES)
WEARPAD (REF)

DETAIL L
B2-4



DETAIL K: END FINISHING DETAIL
B7-4



DETAIL K NOTES
1. CUT TUBE LEVEL
2. REMOVE RIDGE ON FWD SIDE
3. LOCATE D3285-1 (TRIM AS NECESSARY)
4. WELD D3285-1 IN PLACE PER DART QSI 004
5. GRIND FLUSH
6. RIVET D3415-041 NUT PLATE IN PLACE
NOTE: MASK THREADS IN D3415-041
PRIOR TO FINISH

-045 DETAILS

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